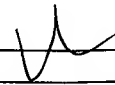
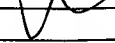


Date: Friday, 22/08/2008 10:32:44 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 3" SKID TUBE HEAVY "I" BEAM
Job Number : 41591	
Estimate Number : 10057	
P.O. Number :	Part Number : D26007140
This Issue : 22/08/2008 S.O. No. :	Drawing Number : D2600 REV D1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : D1
Previous Run :	Material :
Written By : 	Due Date : 29/08/2008 Qty: 93 Um: Each
Checked & Approved By : 	
Comment : Est. A: 04.11.25 New Issue KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

-PG

PURCHASING



Comment: PURCHASING

Issue P/O: 7008

- a) Extrude as per Dwg D2600
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 40 ksi
- e) Minimum elongation = 8%
- f) Order at 140" long
- g) Caradon Indalex Tool # MS-18872
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

2008/08/22

93

93

2.0

D26007140P

EXT. "I BEAM" THICK



Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s)

EXT. "I BEAM" THICK

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

- Receive & Inspect For-Transit Damage
- Ensure material certification is attached

~~HALT 5~~ ~~08/08/15~~ ~~104~~ ~~104~~

104

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

- Inspect dimension per Dwg D2600
- Check Pull test per Dwg D2600 for compliance page attached
- Check hardness with Webster tester

S. 104

104

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/08/2008 10:32:44 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3" SKID TUBE HEAVY "I" BEAM

Job Number: 41591

Part Number: D26007140

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: HALL 5

08/09/15

104

for

counter

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/16

Job Completion

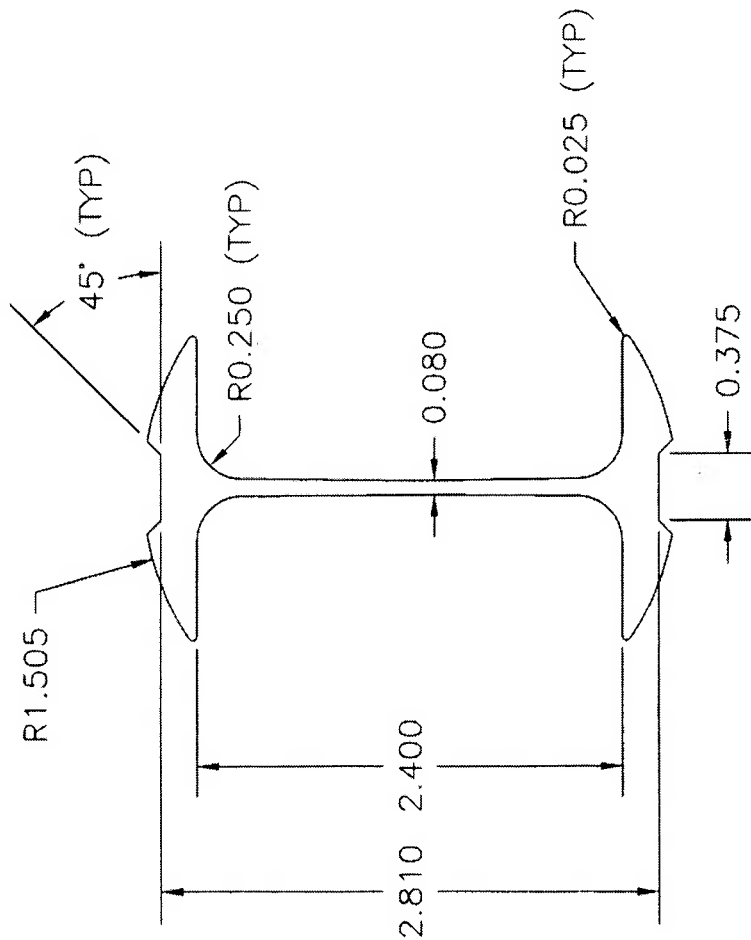


mf 08-09-15



DESIGN <i>DR</i>	DRAWN BY <i>DR</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>JS</i>	DRAWING NO. D2600	REV. D SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS

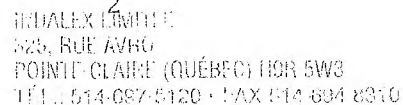


440 41591

D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)





P/S#: 676625

EXPERIMENT / SUMMARY

INDICATORS & LEGENDS
 FIELD INSTRUCTIONS

8090014

K6A1K7

NAME - SAME

CUSTOMER P.S.T.: *6122-5207

INDALEX G.S.T. REG NO: R136834041

PROJ :

Required Date:
080829

[illegible]

DATE RECEIVED DATE SHIPPED	8/09/09	EMPLOYE PAR SHIPPED VIA	OTTAWA 10 SEPT
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N° ITEM NO.	COMMANDE / ORDERED		N° DE MATIERE INDAEX / DIE NO.	DESCRIPTION DU CLIENT CUSTOMER DESCRIPTION	ALLIAGE ET CREPAGE ALLOY AND TEMPER	LONGUEUR LENGTH	PRIX UNITAIRE UNIT PRICE
	POIDS WEIGHT	PIECES PIECES					
				F EXTRUDE ONLY			
				DUE=2008/09/12 ASAP			
1	500		93 MS 18872 D2600-7	6061 T6	3556		
			D-2600-7 HEAVY DUTY				
			BUNDLE= 845077 845104				

We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association, and requirements of our Quality procedures

COMMANDÉ ORDERED	POIDS WEIGHT	Poids Weight	POIDS WEIGHT	MONTANT AMOUNT
	2	555	(104)	POIDS EN KGS

②RS endomorphs MPC

60
~~#97~~
107 me

68/10



325 rue Avro
Pointe-Claire QC H9R 5W3

Téléphone (514) 697-5120
Fac-simile (514) 694-8310

Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : **DART AEROSPACE LTD**

Adresse / Address : **1270 ABERDEEN STREET
HAWKESBURY ONT,
K6A 1K7**

commande Indalex / Indalex order # : **8090014**

bon de commande / Purchase order # : **7008**

de matrice / Die # : **MS 18872** Description : **D-2600-7 Heavy Duty Web**

Alliage & trempage / Alloy & temper : **6061 T6**

Contrôle / Control # : **83196-1**

Coulée / Cast # : **44232**

S
06/09/14

	Min.requis Min.required	Résultat actuel Actual results
Tension ultime Ultimate stress (psi)	38 000	41480
Contrainte élastique Yield stress (psi)	35 000	36434
% élongation dans 2" % elongation in 2"	8	12
Dureté Rockwell E (hre) Rockwell E Hardness (hre)	88 @ 100	91

Composition chimique typique / Typical chemical composition :

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
6063	0,20 - 0,60	0,35 Max	0,10 Max	0,10 Max	0,45 - 0,90	0,10 Max	0,10 Max	0,10 Max
6005	0,60 - 0,90	0,35 Max	0,10 Max	0,10 Max	0,40 - 0,60	0,10 Max	0,10 Max	0,10 Max
6005A	0,68 - 0,72	0,15 - 0,27	0,08 - 0,12	0,20 - 0,24	0,48 - 0,52	0,03 Max	0,05 Max	0,03 Max
6061	0,40 - 0,80	0,70 Max	0,15 - 0,40	0,15 Max	0,80 - 1,20	0,04 - 0,35	0,25 Max	0,15 Max
6351	0,7 - 1,3	0,5 Max	0,10 Max	0,40 - 0,80	0,40 - 0,80	---	0,20 Max	0,20 Max

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221 excepté pour la section 8.2 (nombre de spécimen) et AMS QQA 200/8 excepté pour la section 4.2.3.1 (nombre de spécimen) qui sont déterminés par les exigences du client.

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 except for section 8.2 (number of specimen) and AMS QQA 200/8 except for section 4.2.3.1 (number of specimen) which is determined by customer requirement.

Sincèrement vôtre,
Yours truly,

date : **2008-08-28**

Bruno Morency
Technicien de la qualité
Quality technician

Indalex Limited